












Date: Monday, 22/09/2008 1:03:18 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FITTING
<b>Job Number</b>	: 42170	<b>Part Number</b>	: D32991
<b>Estimate Number</b>	: 10438	<b>Drawing Number</b>	: D3299 REV B
<b>P.O. Number</b>	:	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 22/09/2008 <b>S.O. No.</b> :	<b>Drawing Revision</b>	: B
<b>Prsht Rev.</b>	: NC	<b>Material</b>	:
<b>First Issue</b>	: / / <b>Type</b> : MACHINED PARTS	<b>Due Date</b>	: 29/09/2008 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Previous Run</b>	: 41828		
<b>Written By</b>	:		
<b>Checked &amp; Approved By</b>	: <u>JLD 08.9.22</u>		
<b>Comment</b>	: Est Rev:A 04.10.04 New issue KJ/JLM Est Rev:B 07-06-11 Removed Manual Machining & Hex Bar JLM		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25	
			
<b>Comment:</b> Qty.: 0.2013 f(s)/Unit Total: 4.0257 f(s) <span style="margin-left: 20px;">4</span> 6061T6 BAR 1.250" X1.250" Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.250"X1.250" <span style="float: right;">Batch: <u>M109058</u>  <u>SA 08/09/30</u></span>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
<b>Comment:</b> HARDINGE CNC LATHE SMALL Cut blank: 2.200" long Turn as per Folio FA451 and Dwg D3299 <span style="float: right;"><u>SA 08/09/30</u></span>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;"><u>SA 08/09/30</u></span>			
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
<b>Comment:</b> HAAS Machine as per Folio FA451 and Dwg D3299 CHAMFER PART USING CHAMFER MACHINE AS PER DWG D3299 Deburr <span style="float: right;"><u>J.L 08/10/19</u></span>			
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;"><u>J.L 08/10/19</u></span>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/09/2008 1:03:18 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 42170

Part Number: D32991

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/10/20

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7433

Anodize as per Dwg D3299

Possible Supplier: TNM Paint

Material release note is required

CL 08/10/23

(20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

SS 08/10/30 (20)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 08/10/30 (+20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 82

SS 08/10/31

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/03

Job Completion



U 08/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

E 82641  
 A 05555  
 032  
 5230

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42120
<b>Description:</b> Fitting		<b>Part Number:</b> D3299-1
<b>Inspection Dwg:</b> D3299	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.248	✓			
0.476	+0.000/-0.005	476	✓			
0.550	+/-0.010	552	✓			
1.00	+/-0.030	1.005	✓			
2.10	+/-0.030	2.05	✓			
0.773	+/-0.010	774	✓			
0.10	+/-0.030	.10	✓			
0.20	+/-0.030	.180	✓			
0.550	+/-0.010	559	✓			
MOW for 9/16"-18	Max = 0.5742 Min = 0.5708	5715	✓			
Ø0.302	+0.005/-0.000	Ø.304	✓			
Ø0.688	+0.005/-0.000	683	✓			
Ø0.580	+0.005/-0.000	580	✓			
53°	+/-0.5°	53°	✓			
1.09	+/-0.030	1.090				

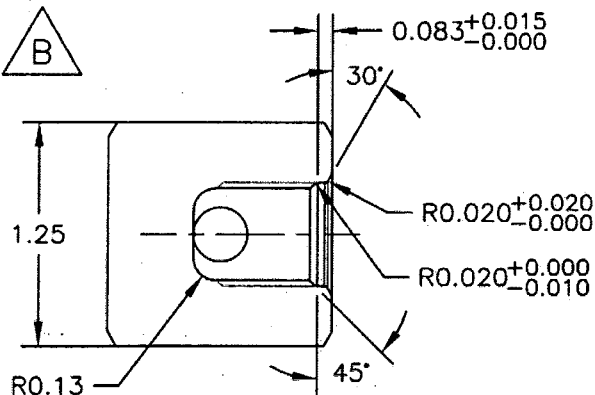
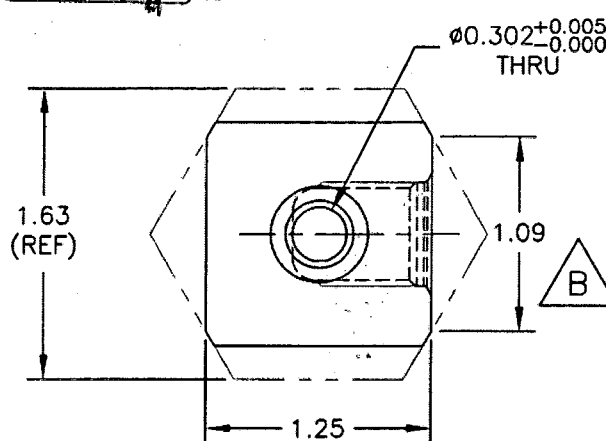
<b>Measured by:</b> SA/JL <b>Date:</b> 8/5/20	<b>Audited by:</b> [Signature] <b>Date:</b> 08/10/20	<b>Prototype Approval:</b> N/A <b>Date:</b> N/A
--	---	--

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.312; 1.09 added	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	
D	08.09.04	Dimensions revised per Rev B	KJ/DD	[Signature]

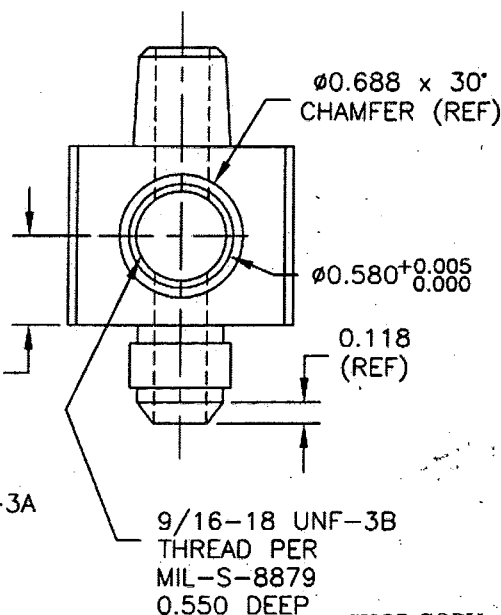
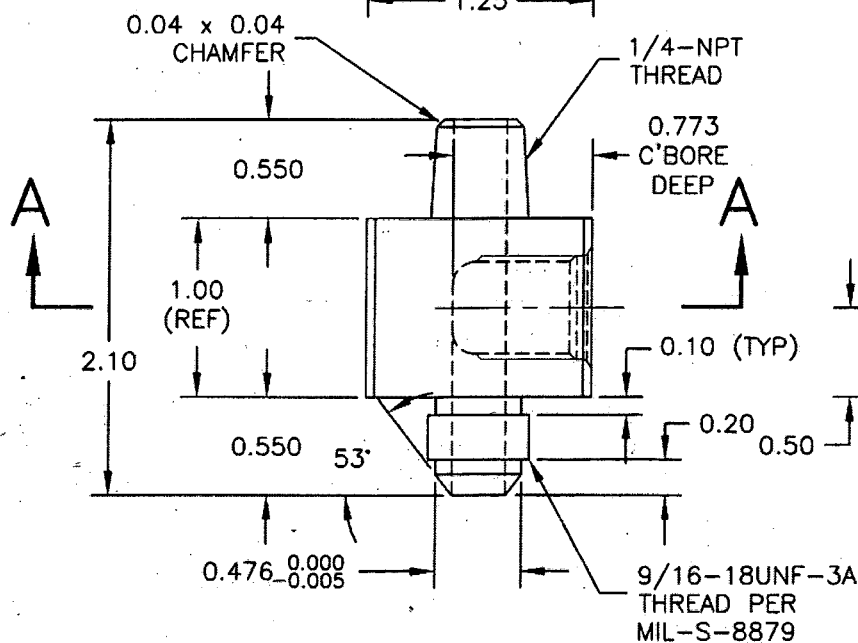


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; Ø0.302 WAS Ø0.297	

RELEASED  
05.04.28



SECTION A-A



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 4210

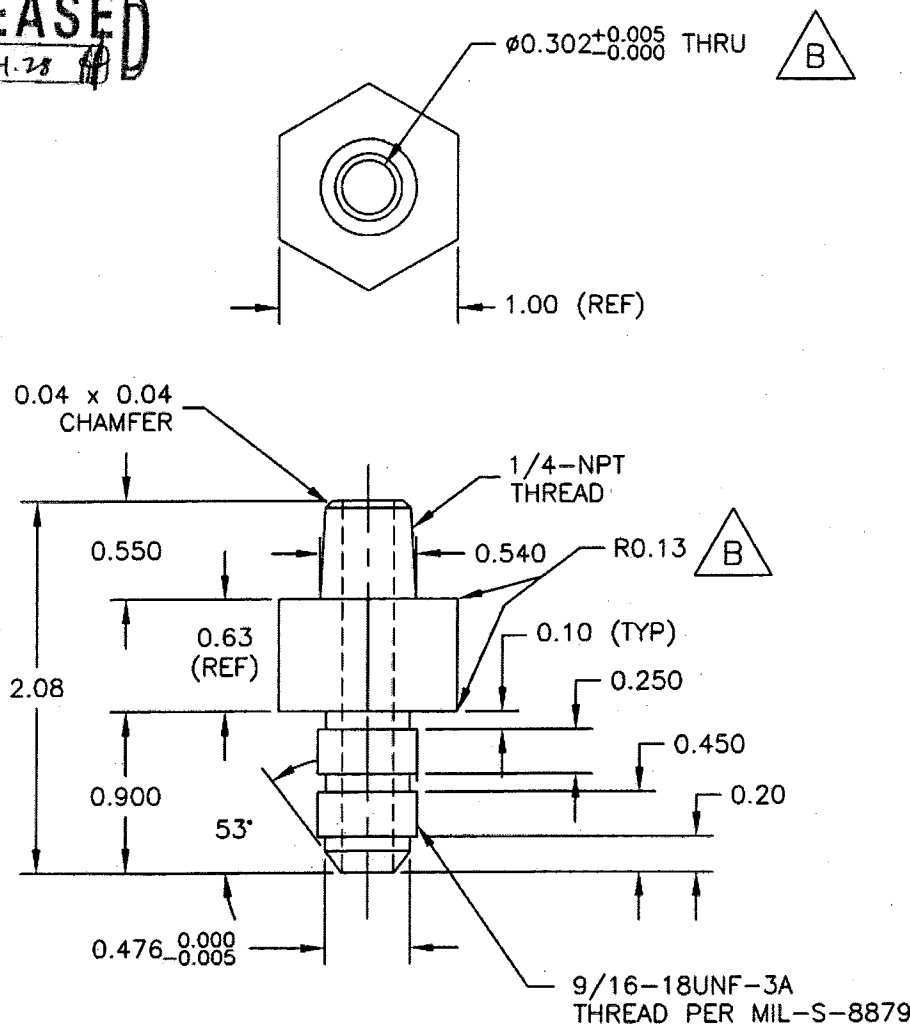
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED  
05.04.28



**D3299-3**

**D3299-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 ED COPY  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY

RETURN TO

FROM ( )

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 4210

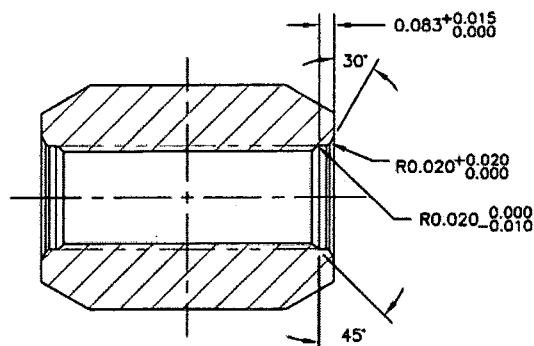
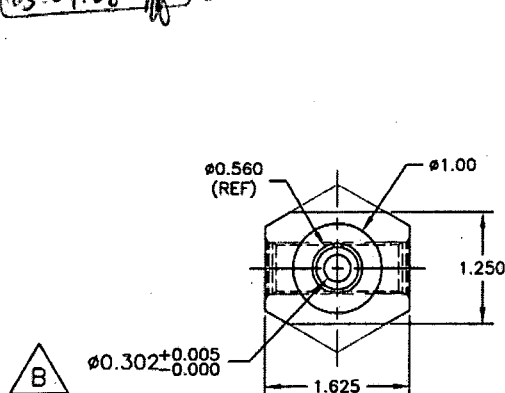
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

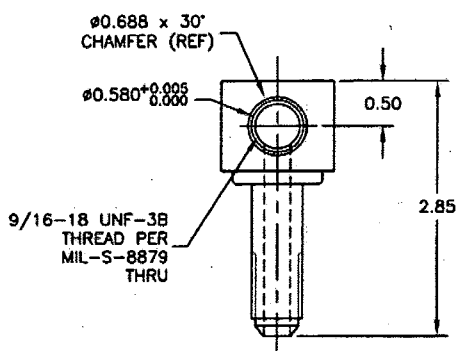
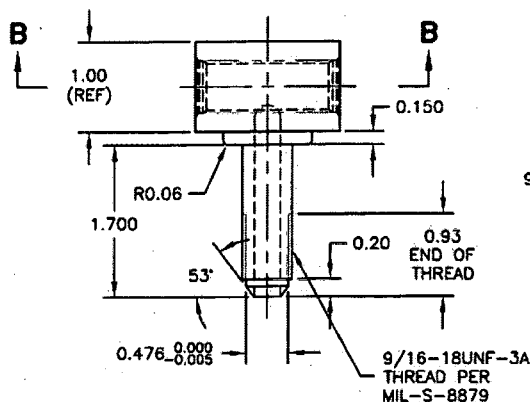


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28	TITLE FITTING		SCALE 1:2

RELEASED  
05.04.28



SECTION B-B  
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4200

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**TNM****ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

69484

28-Oct-2008

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 7433  
PURCHASE ORDER/**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	20	20	D3299-1	B42170	BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
2	3	3	41232-200-002-001	B42265	BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

08/10/36

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

  
Directeur de la Qualité / Q.A. Manager

**TNM****ANODISATION et PEINTURE TNM INC.****FACTURE  
INVOICE**

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

**69484 Rev.00**

28-Oct-2008

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**NO. DE COMMANDE: 7433  
PURCHASE ORDER/****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER DESCRIPTION		PRIX UNITAIRE UNIT PRICE	EXTENSION	
1	20	20	D3299-1	B42170	\$0.00	\$0.00	
2	3	3	41232-200-002-001	B42265	\$0.00	\$0.00	
			<i>MINIMUM CHARGE</i>				\$225.00
			<i>SUB TOTAL:</i>				\$225.00
			<i>TPS/GST:</i>				\$11.25
			<i>TVQ/PST:</i>				\$0.00
			<i>TOTAL AMOUNT DUE:</i>				\$236.25

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

**CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE****CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.